



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4930-1
Job Sheet 170262



Part No: D4930-1

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/26/18

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 13-10-07 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/25/18	0.00	0.00	Start Up Waterjet		OK 18/01/13
110	Waterjet	6 pcs		1/25/18	0.00	1.31	Waterjet1		OK 18/01/13
120	CNC Vertical Machining	6 pcs		1/26/18	0.53	7.23	HAAS1-5		S.S. 18/01/22
140	QC	6 pcs		1/26/18	0.00	0.00	QC8		OK 18/01/23
150	Packaging	6 pcs		1/26/18	0.00	0.00	Packaging3	57454	AT 18/01/24
160	QC21-SA	6 Ea		1/26/18	0.00	0.00	QC21		

Part Op 110 - CUT BLANK AS PER FILE D4930-1 BLANK

Descriptions: 120 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB217 and Dwg

JAN 24 2016

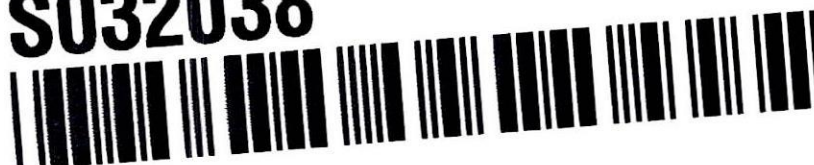
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	8	721	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	12.140Inches $\pm$ 0.030	12.170 12.110		12.140
2	Bearpaw	12.760Inches $\pm$ 0.030	12.790 12.730		12.750
3	Bearpaw	0.380Inches $\pm$ 0.030	0.410 0.350		-38
4	Bearpaw	1.880Inches $\pm$ 0.030	1.910 1.850		1.88
5	Bearpaw	1.190Inches $\pm$ 0.030	1.220 1.160		1.200
6	Bearpaw	0.260Inches + 0.006 - 0.001	0.266 0.259	Diameter	.260
7	Bearpaw	0.880Inches + 0.010 - 0.001	0.890 0.879	Diameter	.882
8	Bearpaw	0.450Inches $\pm$ 0.030	0.480 0.420		.460
9	Bearpaw	3.850Inches $\pm$ 0.010	3.860 3.840		3.853
10	Bearpaw	5.870Inches $\pm$ 0.010	5.880		5.871

DART
AEROSPACE
S032038



Bearpaw

PART NO: D4930 - 1
Original Serial #: S032038
Revision:
Operation:
Change No:

Start up Operation 01/15/18

Job No: 170262

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11	Bearpaw	4.250Inches $\pm$ 0.010	5.860 4.260 4.240	4.250
12	Bearpaw	0.070Inches $\pm$ 0.030	0.100 0.040	-07
13	Bearpaw	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45°
14	Bearpaw	0.250Inches $\pm$ 0.030	0.280 0.220	-250
15	Bearpaw	0.630Inches $\pm$ 0.030	0.660 0.600	-625
16	Bearpaw	0.950Inches $\pm$ 0.030	0.980 0.920	-950
17	Bearpaw	0.130Inches $\pm$ 0.030	0.160 0.100	-130
18	Bearpaw	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45°
19	Bearpaw	0.525Inches $\pm$ 0.010	0.535 0.515	-531
20	Bearpaw	0.375Inches $\pm$ 0.010	0.385 0.365	-381
21	Bearpaw	1.143Inches $\pm$ 0.010	1.153 1.133	1.144

Plex 1/12/18 11:23 AM dart.poulin.mario